

Work Order ID 150574

Friday, September 02, 2016 8:44:42 AM

150574

Page 1

Item ID: D350-591-124 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step™ RH - Low Gear, Short Step, Float Compatible
Start Date: 9/2/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/2/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference: reinspect to current rev *Rework*
Approvals: Process Plan: *W* Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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N/A	Rev F
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100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and type labels as per PPP D350-591-124 CHG004

DAS
27
9-29
SEP 02 2016

105

0.00

105

QC

Memo

0.00

Quality Control

PULL FROM STK:
1 X D350-591-124 B9362
RE-INSPECT TO CURRENT REV.

ADD NEW/UPDATED PARTS A/R:

DAS
27
9-29
SEP 02 2016

DART				TEL.: 1-613-632-3336 FAX: 1-613-632-4443	
TRANSPORT CANADA APPROVAL # 09-89					
P/N	Heli-Access-Step	CHG			
DESC.	D350-591-124	STC	SH92-6		
LOT	B9362	STC	SH967NE		
MODEL	AS350/355	STC			
US PATENT # 5735484 CANADA FOREIGN PATENTS PENDING				MADE IN CANADA	

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Reference: reinspect to current rev

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
107		0.00							
107									
Packaging	Memo	0.00							
Packaging	ENSURE KIT IS COMPLETE								
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									
130		0.00							
130									
Packaging	Packaging	0.00							
Packaging	Memo								
	RE-PACKAGE PER PPP USING NEW B/N NEW LABELS AND PAPERWORK REQ'D								

SEP 02 2016

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Start Date: 9/2/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/2/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference: reinspect to current rev

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

Handwritten notes:
DAS 16 9-89
16/9/12
JMF
16-9-02

Picklist Print

Page 1

Friday, September 02, 2016 8:44:41 AM

Work Order ID: 150574

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Parent Item: D350-591-124

D350-591-124

Parent Item Name: Heli-Access-Step™ RH - Low Gear, Short Step, Float Compatible

Start Date: 9/2/2016

Required Date: 9/2/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:aNew issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-591-124		Manufactured	No				Each	11.0000		1			

D350-591-124

Heli-Access-Step™ RH - Low Gear, Short Step, Float Compatible

Location	Loc Qty	Loc Code
fg070	11	
27870	6	
51595	5	

D2230-1 DAS 27 9-89
D2230-3 DAS 27 9-89
D2732-030 DAS 27 9-89
A03-370 DAS 27 9-89
A04-130 DAS 27 9-89
A04-16A DAS 27 9-89
NAS114900363 DAS 27 9-89
NAS114900403 DAS 27 9-89
MS2104263 DAS 27 9-89
MS2104264 DAS 27 9-89

X1 B146288 PC
X1 B146287 PC
X2 B149044 PC
X2 M134180 PC
X1 M135464 PC
X2 M135297 PC
X4 M134955 PC
X6 M135390 PC
X2 M135138 PC
X3 M135297 PC

Lon:

→ Will need a work order to pull B350-S91-123
B9361 and inspect to current change number
(change). ID with new B#. new label and paper work.
Some thing with B350-S91-124 B9361

Sylvain

→ inspect stop with blue file and add any missing
parts.
Scrap and replace B2230-1/3 with new one
Record all changes on the back of the w/o.
Change stickers

P.D.

150573

150574

9362

Lori

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER
REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE

For D350-591-121/-122/-123/-124/-133 steps, customers have the option of installing D2732-030 cushions under the D2230-1/-3 clamps to accommodate varying crosstube diameters and to improve fit. It is also acceptable to use longer or shorter AN4 bolts, and/or extra AN960JD416 washers under the nut to ensure 1.5 to 4 threads in safety. See Figure 1 on sheet 2 of this service instruction for reference.

For D350-591-121/-122 steps at CHG 005, D350-591-123/-124 steps at CHG 004, and D350-591-133 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -121	Qty -122	Qty -123	Qty -124	Qty -133	Part Number	Description
X					D350-591-121	Heli-Access-Step™, Short Step – High Skid, LH
	X				D350-591-122	Heli-Access-Step™, Short Step – High Skid, RH
		X			D350-591-123	Heli-Access-Step™, Short Step – Low Skid, LH
			X		D350-591-124	Heli-Access-Step™, Short Step – Low Skid, RH
				X	D350-591-133	Heli-Access-Step™, Aft Maintenance Step
2	2	2	2	8	D2732-030	CUSHION
2	2	2	2	8	AN4-16A	BOLT

The DSI-9459-011 kit is available for customers with earlier model D350-591-121/-122/-123/-124 steps. Longer AN4 bolts are provided to fasten the clamps. The DSI-9459-013 kit is available for customers with earlier model D350-591-133 steps.

Qty -011	Qty -013	Part Number	Description
X		DSI-9459-011	Rubber Cushion Kit (for -121/-122/-123/-124 steps)
	X	DSI-9459-013	Rubber Cushion Kit (for -133 steps)
2	8	D2732-030	CUSHION
2	8	AN4-16A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: D. SHEPHERD (DE # 02)

DATE: 09.06.24
CERT. NO.: SH92-6
ISSUE NO.: 11

B	AN4-16A WAS -17A FOR -013/-133 KIT	CP	09.06.24
A	NEW ISSUE	CP	09.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN	GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	GP	DRAWING NO.	REV.
CHECKED	PL	DSI 9459	SHEET 1 OF
MFG. APPR.	N/A	TITLE	SCALE
APPROVED	MD	OPTIONAL CLAMP MODIFICATIONS	
DE APPR.	MD	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITH WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.06.24		